

Grooving Insert Z4

A08-350

Grooving Inserts chucked through TTC are ground profiled inserts on edge. The advantage of TTC clamping: all operations to accomplish a finished tool are executed in one setup. The accessibility of all 4 cutting edges makes indexing as simple as just rotating the A-Axis.



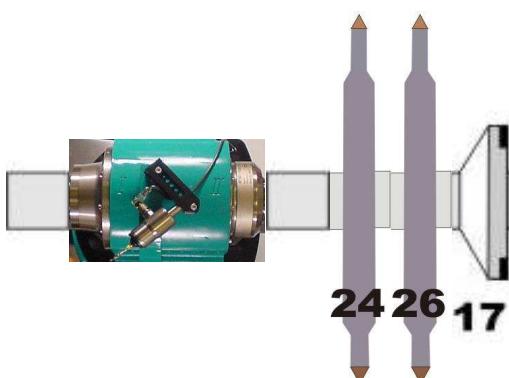
1. Cycletime for Production

Tool specifications BxSxS: 2.0x25x25 Material CARBIDE				
Operations	Probe A Pos	Chip Breaker	Prof. Prgrd	Prof. Fin.
Feed [mm/Min]	2000	50	45	80
Power [kW]		4	1	1
Cutting feed [m/s]		22	24	24
Used wheels				
Grinding time [s]	8	51	147	135
Total cycle time	5 Min 41			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

17 Ø125 12A2 D64
26 Ø300 14V1 D46
24 Ø300 14V1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM, STL 650

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 4.3

responsible engineer: OP,19.11.07

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